

Work Order ID 126354

126354

Page 1

Wednesday, November 05, 2014 7:47:08 AM

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Door RH
 Start Date: 11/5/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/5/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-11-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>26420</u>								
	Description: D3186-2M Door								
	Supplier: Delastek								
	Conformity Certificate and Process sheet required								
	Ship 3 Items from Previous steps								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

CL 14/11/070

IX SP 15035

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D3186-2M Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Spacepod Door RH

Start Date: 11/5/2014 Start Qty: 1.00 *1*

Required Date: 11/5/2014 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>CA2</u>	0.00							
130									
Packaging	Memo	0.00							15-03-09
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							ML5 1503-10
Quality Control									

15-3-10

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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, November 05, 2014 7:47:11 AM

Page 1

Work Order ID: 126354

126354

Parent Item: D3186-2M

D3186-2M

Parent Item Name: Spacepod Door RH

Start Date: 11/5/2014

Required Date: 11/5/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P		Purchased	No			110	Each	0.0000	1	1			

D3186-2P

Spacepod Door

SP 15-035.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

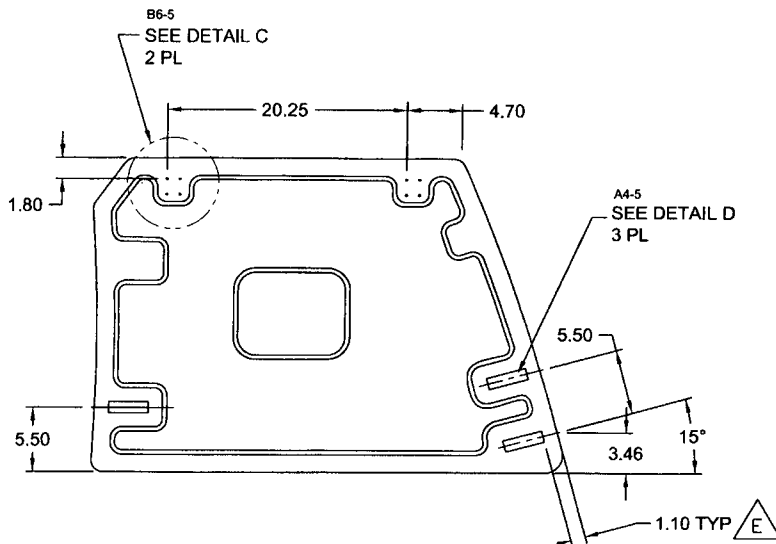
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Training									
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FAULT CATEGORY

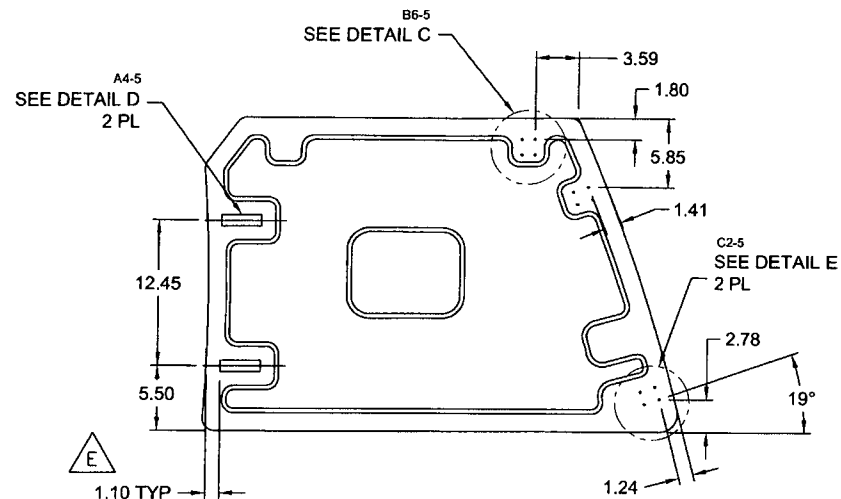
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126354.MLS
14-11-05

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D3186	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

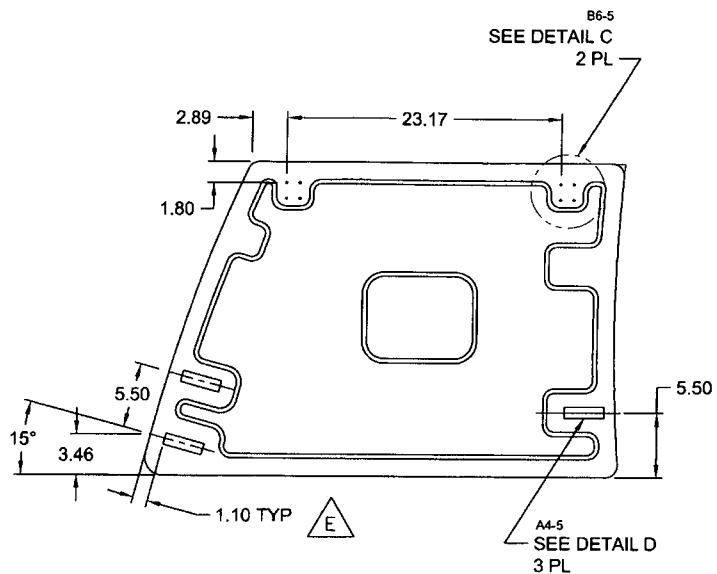
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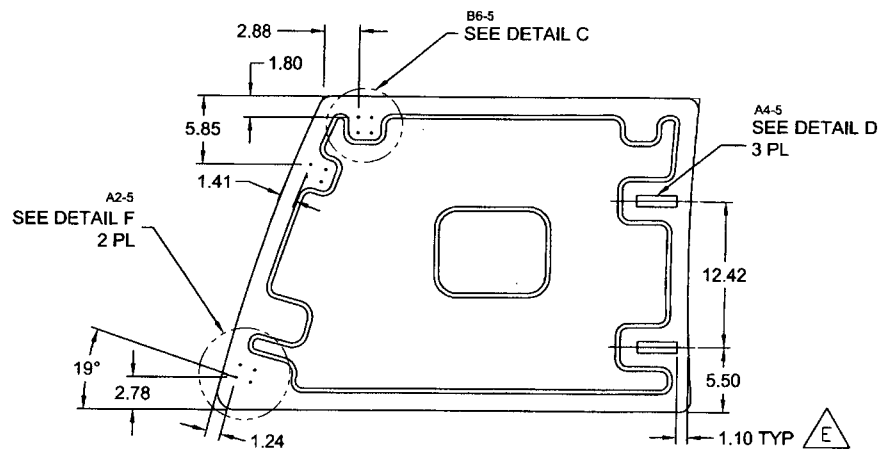
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2009-09-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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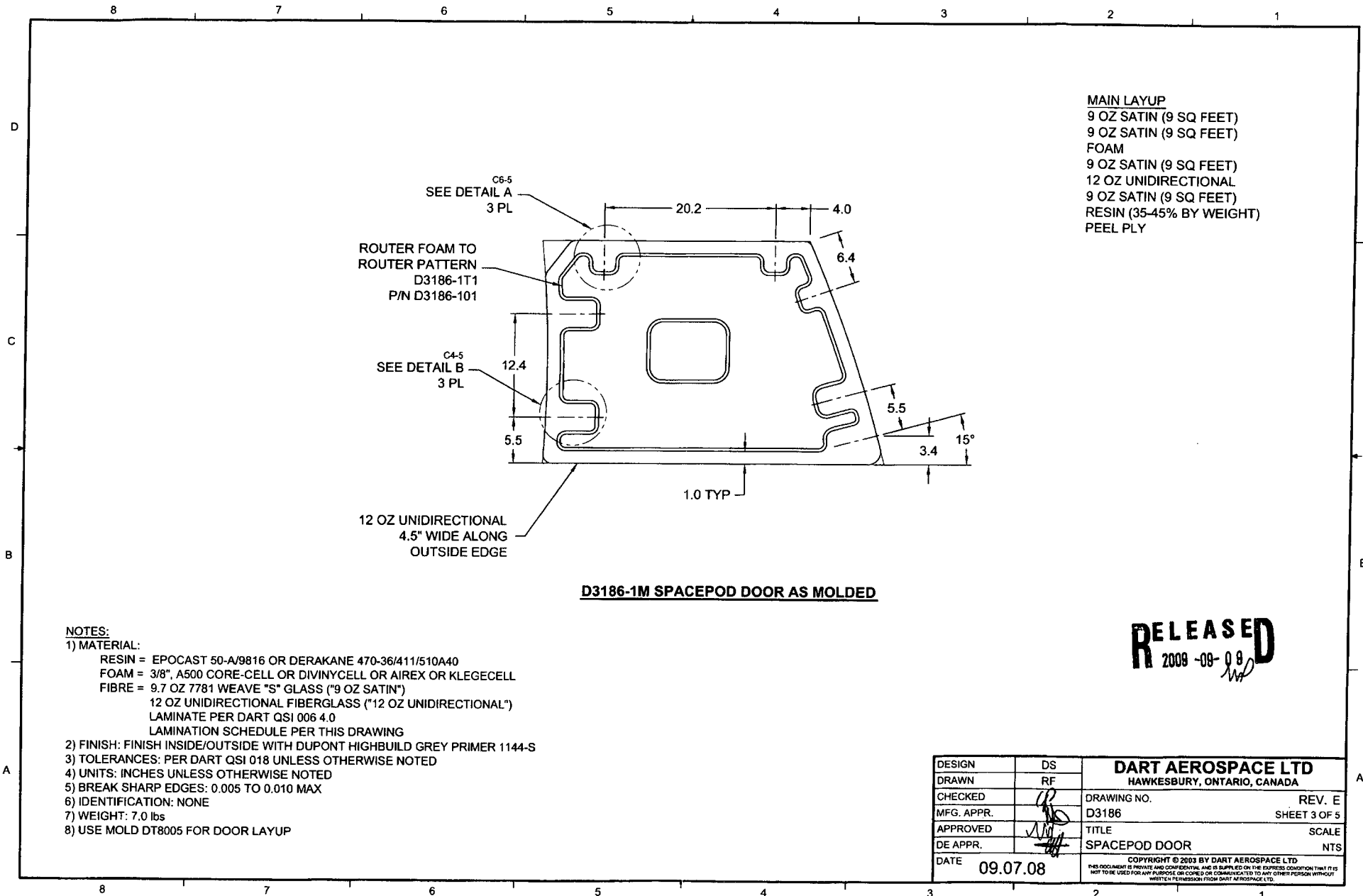
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Work Order update only ☐

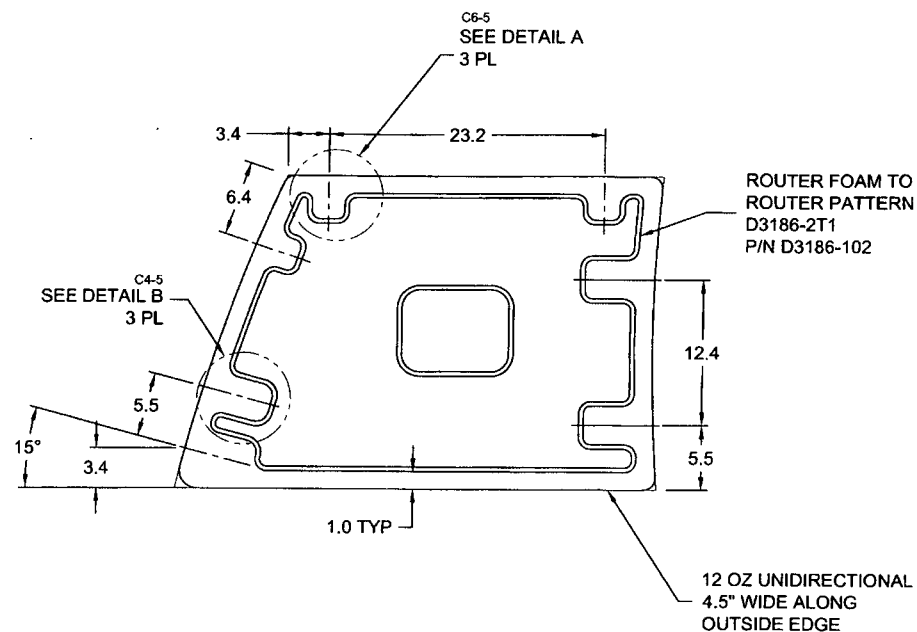
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

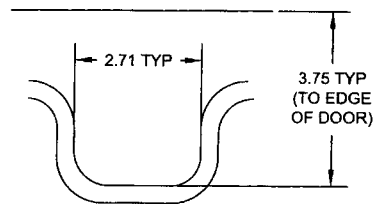
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

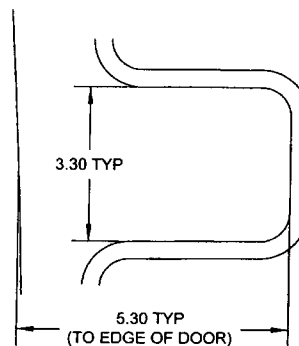
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

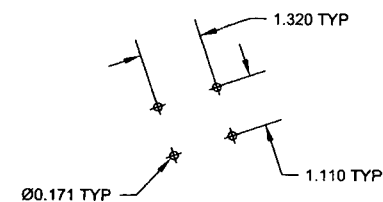
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--	--



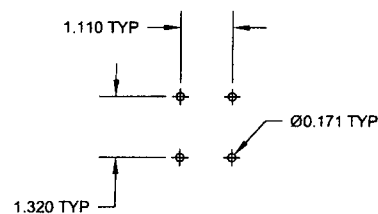
DETAIL A D6-3
SCALE 4X D4-4



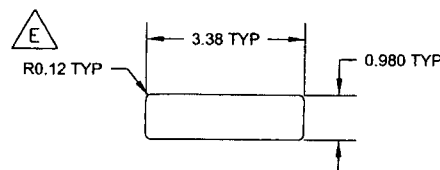
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

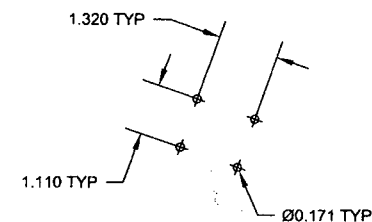


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-08

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26420**

Purchase Order Date 11/7/2014

PO Print Date 11/7/2014

Page Number 1 of 2

Order From :

VU-DEL003

Ship To : DART AEROSPACE LTD

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone 819 533 5788

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via:

FedEx Overnight collect

FOB

FCA - (Free Carrier)

Ship Acct:

*REVISED
date.*

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3186-2P MAKE AS PER DWG D3186 REV.E B126355	Spacepod Door	12/12/2014 Yes 12/12/2014 2/27/2015		1.00 Each	\$726.64	\$726.64
Line Total:							\$726.64
2	D3188-2P MAKE AS PER DWG D 3188 REV.G B126357	Spacepod Body	12/12/2014 Yes 12/12/2014 2/27/2015		1.00 Each	\$2,224.89	\$2,224.89
Line Total:							\$2,224.89
3	D3186-2P MAKE AS PER DWG D3186 REV.E B126354	Spacepod Door	11/6/2015 Yes 11/6/2015 2/27		1.00 ✓ Each	\$726.64	\$726.64

2015-03-5

Note:

DELASTEK

DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	59512
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Contact : D.Bates

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-03-2015	20-11-2014	25217	Chantal Lavoie	PO26420	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
Fedex Freight LTL Collect		Point de départ	Melody Shapcott, ext. 235		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0060	Line 1 N° D3186-2M Spacepod Door RH B1263 U of M: Chaque Dwg. D3186 Rév.: E Serial # Lot # 66241 66241	
1	0	1	DKC134-0071	Line 2 N° D3188-2M, Spacepod Body RH B1263 U of M: Chaque Dwg. D3188 Rév.: G Serial # Lot # 66243 66243	
1	0	1	DKC134-0060	Line 3 N° D3186-2M Spacepod Door RH B1263 U of M: Chaque Dwg. D3186 Rév.: E Serial # Lot # 66242 66242	
1	0	1	DKC134-0071	Line 4 N° D3188-2M, Spacepod Body RH B1263 U of M: Chaque Dwg. D3188 Rév.: G Serial # Lot # 66244 66244	

DOCUMENT INCLUS



It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

4/12 jan

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD DOOR RH	Qté:	1 Udm: UNITE
Numéro Job	: 66241	Numéro Article	: DKC134-0060		
Numéro Soumission	: 3769	Numéro Dessin	: -		
Numéro B.A.	:	Projet Numéro	: DK-362		
Cette fois	: 2015-01-06 No. B.V. :	Révision dessin	:		
Prsht Rev.	: NC	Matériel	: 7781 & 411-350		
Prem. fois	: - - Type :	Date Dûe	: 2015-02-16		
Job précédente	: 64577				
Écrit par	:				
Vérifié & Approuvé par	:				
Commentaires	: N° de dessin: D3186-2M rev. E				



E.O.: N/A

Feuille de Procédé Rév.: 03 AMB0349 remplacé par AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

COPIE

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description:

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo N° de Lot: 4802810AA

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: 13/01/15 Sceau: 56



3.0 AAC1885 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total: 3.28 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

4.0 AAC1887 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total: 3.59 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 66241		Numéro Article: DKC134-0060	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AC0943	Stretchlon 200 poche à vide Vert	
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)			
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Commentair Qty.: 4.50 VERGE(s)/Unit Total : 4.50 VERGE(s)			
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-49418-1			
8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)			
9.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Commentair Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)			
N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1			
10.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
Tailler le matériel selon les différents patrons de découpe.			
Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.			
Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.			
Date: 13/01/15 Sceau:  \$ 43285.B			
11.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0080 GALLON(s)/Unit Total: 0.0080 GALLON(s)			
Catalyst N° DDM-9 N° de Lot: 1-27829-1			
12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)			
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4900610AA			
13.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			
Date: 13/01/15 Sceau:  43285.B			

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 66241

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date:

13/01/15

Sceau:



4328 5.B

15.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing:

3:00

Heure Fin Curing:

8:00

Date:

13/01/15

sceau:



4328 5.B

16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total: 0.0120 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

4900610AA

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date:

13/01/15

Sceau:



4328 5.B

19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

N° de Job:

66278

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 66241		Numéro Article: DKC134-0060	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AAC1611	Polybond B46F	
Commentair Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s) Polybond B46F N° de Lot: <u>1-40597-1</u>			
21.0	ASSEMBLAGE	Assemblage mécanique	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Retirez le bagging.			
Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.			
Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)			
Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.			
Date: <u>14/01/15</u> Sceau:  			
22.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012.			
Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.			
Heure début Curing: <u>11:00</u> Heure Fin Curing: <u>12:15</u>			
Date: <u>14/01/15</u> sceau:  			
23.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
24.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>4900610AA</u>			
25.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 66241

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 15/01/15 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 13 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 15/01/15 Sceau:

4328 5B



27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 3:00

Heure Fin Curing: 8:00

Date: 15/01/15 Sceau:

4328 5B



28.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 16/01/15 Sceau:



29.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 16/01/15 Sceau:



Date : Mardi, 2015-01-06 13:39:22
Utilisateur : marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 66241

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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30.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

31.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 4768410 AA

32.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Run : 0.5000Hrs

2^e cote 22 Jan 2015
Appliquer une couche de primer selon IG 0008.



10591

1^{re} cote Date: 19 Jan 2015 Sceau: # de fiche de mélange: 10589

33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
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Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler N° de Lot: 4795520AA

34.0	FINITION	Finition Générale
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 21/01/15 sceau:

35.0	AAC1021	Dupont Primer N° 7704S
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Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

36.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
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Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-46475-2

37.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

2^e cote 22 Jan 2015
Appliquer une couche de primer selon IG 0008.



10595

1^{re} cote Date: 21 Jan 2015 Sceau: # de Fiche de mélange: 10594

Date: Mardi, 2015-01-06 13:39:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 66241

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

38.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

22-01-15

Faire l'inspection finale par la qualité selon le dessin.

intérieur

Date: 23-01-15 Sceau:



extérieur

39.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 23/01/15 Sceau:

